

Date: Monday, 8/13/2007 1:13:31 PM  
 User: Jean-Luc Menard

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services      Job Name : 206 EXTRUSION BENDING  
 Job Number : 33880  
 Estimate Number : 10311  
 P.O. Number : N/A      Part Number : D2620  
 This Issue : 8/13/2007      S.O. No. : N/A      Drawing Number : D2620 REV B  
 Prsht Rev. : NC      Project Manager : N/A  
 First Issue : N/A      Type : LANDING GEAR      Drawn By : B  
 Previous Run : 33879      Material : N/A  
 Written By : JA/07-08-13      Date : 8/20/2007      Qty: 20 U/m: Each  
 Checked & Approved By :  
 Comment : Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26001160	Extrusion Round 3" 206
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Comment: Qty.: 1.0000 Each(s)/Unit      Total : 20.0000 Each(s)

Extrusion Round 3" 206

Pick;

Qty	Part Number	Description	Batch
1	D2600-1	Extrusion Round 3"206	30249

EL 7-8-27

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A  
 and Folio F1008

2- Cut Fwd end of tube as per Dwg D2620

EL 7-8-27

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

BE 7-09-06

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

BE 7-09-06

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

BE 7-09-06

Job Completion

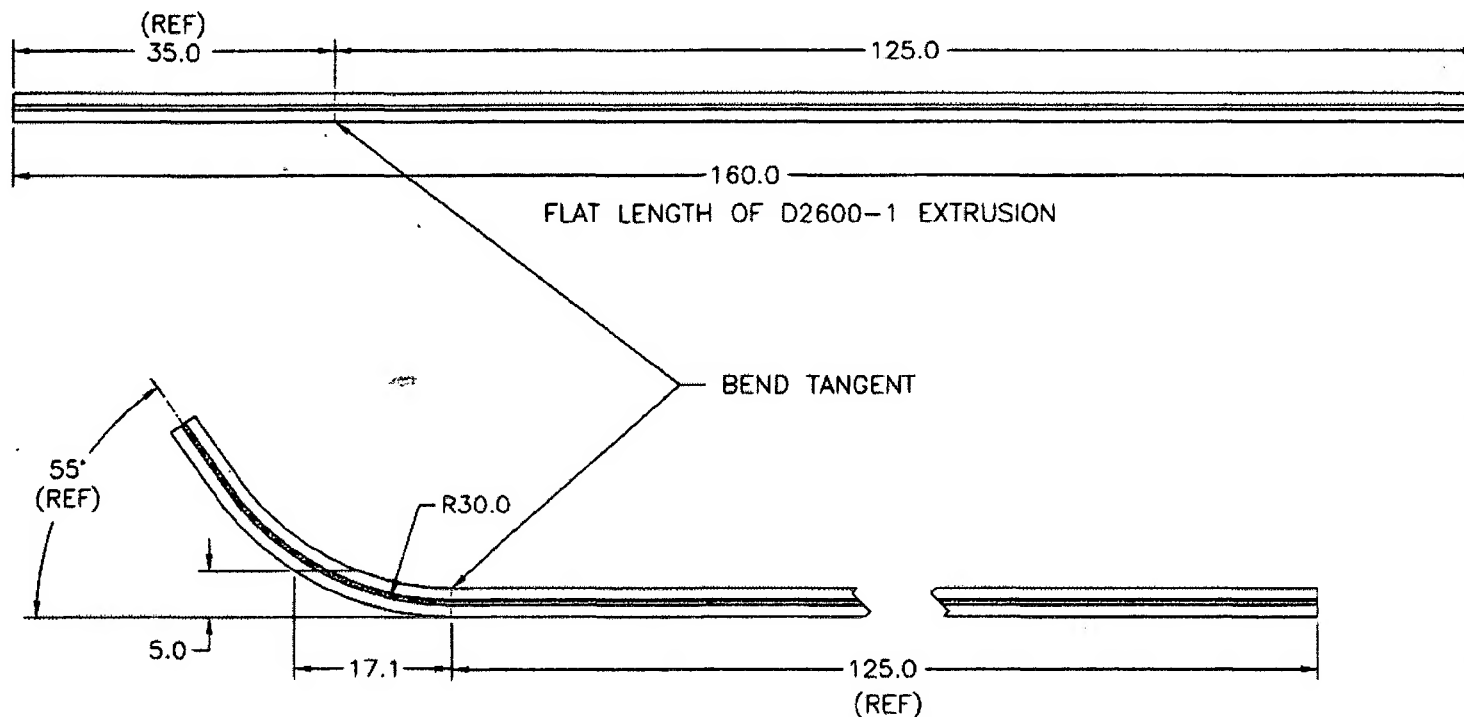


u 7-09-06

# SPECIFICATION CONTROL DRAWING

## 206 SKIDTUBE BENDING

**DART**



### DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE. NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE. DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE  $3.20 \pm 0.200$  IN THE BEND. TUBE WIDTH SHOULD BE  $3.200 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE  $3.15 \pm 0.200$  IN THE BEND. TUBE HEIGHT SHOULD BE  $3.150 \pm 0.010$  IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

**RELEASED**  
99 09 15 DS

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CHECKED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
DATE		DRAWING NO.
99.09.10		D2620
		TITLE
		206 SKIDTUBE BENDING CONTROL
		SCALE
		1:20
A	97.11.07	NEW ISSUE
B	97.09.10	UPDATE FOR IN-HOUSE BENDING